

NAVSHIPREPFAC YOKOSUKA  
LOCAL STANDARD ITEM

FY-02

ITEM NO: 099-31YO  
DATE: 01 JUL 2001  
CATEGORY: II

1. SCOPE:

1.1 Title: Boiler Waterjet Cleaning; accomplish

2. REFERENCES:

- a. S6300-AE-MMA-010, Waterjet, Model WBD-150N; Operation, Maintenance, Repair and Overhaul Procedures

3. REQUIREMENTS:

3.1 Accomplish waterjet cleaning of boiler watersides, using manufacturer's equipment manual and 2.a for guidance.

3.1.1 Portable extension lights shall conform to MIL-F-16377/49, Symbol 306.2 or MIL-F-16377/52, Symbol 286.

3.1.1.1 Ground each light fixture at the voltage source.

3.1.2 The high pressure waterjet cleaning unit shall be operated at no more than 10,000 pounds per square inch (PSI).

3.1.3 Rope off and post warning signs in the areas where the unit is operating, where the high pressure hose is run, and where the waterjet cleaning is to be accomplished.

3.1.4 Unit shall be stopped immediately if high pressure leaks occur in pump, piping, high pressure hose, or hose couplings.

3.1.5 While personnel are waterjetting, lance operator shall be in direct visual contact with control gun operator stationed outside of boiler.

Control gun operator shall also maintain direct person-to-person voice communication with pump operator, using telephone, radio, or other positive direct means. Communication relay through intermediaries is not acceptable.

3.1.6 The control gun operator shall be able to regulate the flow of water to permit the system to be pressurized during the actual tube cleaning and have the nozzle pressure reduced to zero while the operator removes the lance from one tube and inserts it into the next tube to be cleaned.

3.2 Cleaning equipment shall meet minimum requirements listed herein:

3.2.1 Supply hose from the pump to the control gun shall be 1/2 inch inside diameter (I.D.) with 30,000 PSI minimum burst pressure and shall not exceed 400 feet in length. A 15-foot length of supply hose shall be attached between the control gun and the flexible lance.

3.2.2 Provide a high pressure return line from the control gun dump connection to the waterjet supply tank, on units that discharge pressure to the bilges between cycles.

3.2.3 Tube cleaning nozzle shall be nonrotating. Orifices in the nozzles shall be angled back 30 degrees. Nozzles shall have a minimum of 18 orifices evenly spaced around the circumference. Each orifice shall be 0.024 inch in diameter, plus or minus 0.001 inch.

3.2.4 Fan pattern nozzle attached to a rigid lance for cleaning drum and header surfaces.

3.2.5 Lance and nozzle burst pressure ratings shall be 25,500 PSI minimum. Lance shall be 0.229 inch or larger I.D. and shall have a smooth Teflon core, and shall not exceed 25 feet in length.

3.2.6 Waterjet cleaning solution shall consist of one pound of sodium nitrite to 100 gallons of clean, fresh water.

3.3 Maintain operating pressures and flow rates for boiler cleaning as follows:

3.3.1 Boiler tube cleaning - 10,000 PSI maximum, **9,000** PSI minimum pump discharge pressure at 20 gallons per minute.

3.3.2 Drum and header surface cleaning - 7,500 PSI maximum, **6,500** PSI minimum pump discharge pressure, at 12 to 14 gallons per minute.

3.4 Verify water jet cleaning equipment capability prior to commencement of work.

3.4.1 Place the lance and nozzle which will be utilized in waterjet cleaning securely into a container. Ensure lance cannot break loose and that unit output is 20 gallons per minute.

3.5 Accomplish cleaning operations as follows:

3.5.1 Lance and nozzle shall traverse the entire length of every tube cleaned.

3.5.1.1 Downcomer, riser, and support tubes shall be traversed twice.

3.5.2 The lance and nozzle shall traverse the tubes at a maximum rate of one foot per second.

3.5.3 A fan nozzle shall be used to clean entire interior drum surfaces.

3.6 Pump waterjet wastewater effluent from boiler to a holding container or a waterjet wastewater recycling unit. Do not drain wastewater to bilges.

3.6.1 Waterjet wastewater recycling filter process shall be capable of filtering the wastewater effluent to meet the following criteria:

|                  |                    |
|------------------|--------------------|
| Suspended Solids | < 10 mg/L          |
| Sodium Nitrite   | 1,100 - 1,300 mg/L |
| Ph               | 6.5 - 8.5          |
| Nitrate          | < 10 mg/L          |
| Oil and Grease   | < 5 mg/L           |

3.6.1.1 Recycled wastewater discharge samples shall be taken every 3,000 gallons to ensure levels do not exceed the above criteria.

3.6.1.2 Submit four legible copies of a report listing the results of the requirements of 3.6.1.1 to NAVSHIPREPFAC.

3.6.2 Remove and dispose of spent chemicals and solutions in accordance with Japanese laws, and local regulations.

3.7 Dry tubes, headers, drums, and downcomers using clean, dry air immediately upon completion of waterjet cleaning. Remove pockets of water and dry surfaces using clean rags.

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3.8 Inspect surfaces to ensure the following requirements are met:

3.8.1 Surfaces shall be dry.

3.8.2 There shall be no evidence of flash rusting.

3.8.3 There shall be a streaking effect seen when looking into the tubes. The streaking effect shall begin within one to two inches from the tube end and continue through the visible length of the tube.

3.8.4 Soft deposits and obstructions shall be removed.

3.8.4.1 Submit four legible copies of a report listing location of obstructions that cannot be removed by waterjet cleaning to NAVSHIPREPFAC.

3.8.5 Residual sodium nitrite deposits remaining after the surfaces are dried is acceptable.

4. NOTES:

4.1 None.